

5/10

DART AEROSPACE LTD	Work Order:	22324
Description: Blade Fitting RH	Part Number:	D2742-2
Dwg: D2742 Rev. B1; DSK-050 Rev. A; D6103 Rev. A	Qty:	8 6
		Page 1 of 1

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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	KJ	05.01.26	8
2	PG	Issue P/O: <u>2007477</u> Material: 7075-T6/T651 (QQ-A-200/11 or QQ-A-225/9) 3.250" OD x 12.500" Long (+0.100/-0.030) per P/N D6103-001 Certificate of Conformity is required	LL	05.01.27	10
3	RG	Receive and Inspect for transit damage Ensure Certificate of Conformity is attached	CL	05/02/02	9
4	QC6	Inspect dimensions as per Dwg D6103	EC	05.04.19	9
5	MS RG	Machine as per Folio FA099 (Note: Lathe work only!) ISSUE PO 2007925 FOR DSK 050	LL	05.04.20	8
6	QC2 RG	Inspect parts as they come off the CNC machine RECEIVE & INSPECT FOR TRANSIT DAMAGE	CL	05/05/13	7
7	QC8 QC6	Second inspection DIMENSIONAL CHECK	EC	05/06/27	7
8	MV	Machine as per Folio FA099 (Note: HAAS work!)	EC	05/06/27	7
9	QC2	Inspect parts as they come off the CNC machine	EC	05/06/27	7
10	QC8	Second inspection	EC	05.06.29	7
11	FP	Chemical Conversion Coat as per QSI 005 4.1	FF	05.07.07	6
12	FP	Powder Coat White (REF 4.3.5.1) as per QSI 005 4.3	FL	05.07.08	6
13	QC3	Inspect Powder Coat	FL	05.07.08	6
14	FP	Install ALS4-1032-225 Insert as per Dwg D2742 Qty Part Number Description Batch 4 ALS4-1032-225 Insert <u>M191576</u> or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	FC	05.07.13	6
15	QC5	Inspect part 100% for completeness on the W/O	MM	05.08.02	6
16	FP	Identify and Stock	MM	05.08.02	6
17	AC	Cost / part <u>216.14</u>	SAC	05.09.02	6
18	DC	Close W/O <u>182.94</u> Inspect Level 21	EC	05/09/02	6

0

Rev.	Date	Change	Revised By	Approved
A	98.09.09	New Issue	DS/CP	
B	98.11.02	Blank size, inspection level added	KS	
C	99.02.02	Changed Procedure, Insert	DM	
D	00.11.01	Removed P/O for Powder Coat & for turning	EC	
E	00.11.17	Added picking DSK-050	EC	
F	02.05.07	Added turning sequence(remove DSK 050)	NG	
G	02.09.20	Re-format; Added P/O	KJ	
H	04.03.09	Added Steps 3 & 4	KJ/RF	

RELEASED
04.04.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	22324
Description: Blade Fitting		Part Number:	D2742-2
Inspection Dwg: D2742 Rev: B1; DSK050 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
LATHE	8.000	+0.030/-0.000	8.005	✓			
	9.250	+/-0.010	9.249	✓			
	Ø3.240	+0.005/-0.000	3.240	✓			
	Ø3.125	+0.005/-0.000	3.126	✓			
	Ø2.780	+0.005/-0.000	2.780	✓			
	Ø2.450	+0.005/-0.000	2.450	✓			
	0.125 x 45°	+/-0.010	0.125 x 45°	✓			
	0.125	+/-0.010	0.123	✓			
	12.50	+0.030/-0.000	12.50	✓			
HAAS	0.100 x 0.135	N/A	N/A				
	0.500	+0.005/-0.000	0.501	✓			
	1.500	+/-0.005	1.498	✓			
	11.46	+/-0.030	11.495	✓			
	1.180	+/-0.005	1.181	✓			
	3.150	+/-0.005	3.149	✓			
	3.500	+/-0.005	3.501	✓			
	Ø0.484	+0.005/-0.000	0.484	✓			
	Ø0.508	+0.005/-0.000	0.508	✓			
	1.000	+/-0.010	0.997	✓			
	0.926	+/-0.010	0.929	✓			
	0.500	+/-0.010	0.504	✓			
	1.230	+/-0.010	1.227	✓			
	0.125	+/-0.010	0.132	✓			
	2.620	+/-0.010	2.625	✓			
	0.297	+0.005/-0.000	0.297	✓			
	Ø0.430 x 0.045	+/-0.010	0.433 x 0.048	✓			

Measured by: <i>En</i>	Audited by: <i>JML</i>	Prototype Approval:	N/A
Date: 05/06/27	Date: 05/06/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.12	New Issue	KJ/RF	<i>[Signature]</i>

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 25, 2005
03:20 pm

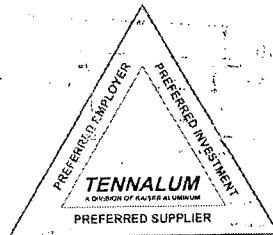
Work Order No	: 0022324	Department Code:	
Project Name	: D2742-2	Burden Flags	: NNNNNNN
Project For	: WK510	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2742-2	Invoice Number	:
Description	: Blade Fitting, RH	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 8	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 01-25-05		
Est Finish Date	: 03-03-05	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var\ %	Posted	To Post
=====					
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====					
Burden	: 0.00	0.00	0.00		
=====					
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

KAISER ALUMINUM FABRICATED PRODUCTS

Tennalum
PO Box 669
Jackson, TN 38302
731-423-2811



CERTIFIED TEST REPORT
<http://KaiserEngProd.com>

CUSTOMER PO NUMBER: CA2192		CUSTOMER PART NUMBER: 024363		PRODUCT DESCRIPTION: SMS CF RD Specific Length	
KAISER ORDER NUMBER: 595936	LINE ITEM: 1	SHIP DATE: 11/15/2004	ALLOY: 7075	TEMPER: T651	
WEIGHT SHIPPED: 969 lbs.	QUANTITY: 8 pcs.	B/L NUMBER: 22409	DIAM/DAF/THKNS: 3.250 in.	WIDTH: 0.000 in.	LENGTH: 144.0 in.
SHIP TO: Copper & Brass Sales Inc 6555 E Davison Detroit, MI 48212 USA			SOLD TO: Copper & Brass Sales Inc Attn: Accounts Payable P. O. Box 5116 Southfield, MI 48086-5116 USA		

Test Code: 1000

Actual Physical Properties

Lot Number	LONG. UTS ksi	LONG. YTS ksi	LONG. ELONG. %
20061200	80.2	72.9	16.0

Chemical Composition, WT. % (Aluminum Remainder)

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	OTHERS EACH	OTHERS TOTAL
Max	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.15
Min			1.2		2.1	0.18	5.1			

Specifications

Standard: ISO 9001, ASTM B211-03, AMS 4123G, AMS-QQ-A-225/9

Miscellaneous Notes

This material was melted and manufactured in the USA. Mercury is not a normal contaminant in aluminum alloys. Neither mercury nor any of its compounds were utilized by Kaiser Aluminum in the manufacture of this material. This material meets the requirements of (cold finished) T6 temper, AMS 4122J and QQ-A-225/9E (CANCELLED).

CERTIFICATION

Kaiser Aluminum & Chemical Corporation ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

Plant Serial: 44125

Kaiser Order Number: 595936

Line Item: 1

Delivery Slip: 05442
Date: 12-May-2005
Page No.: 1

Sold To: Dart Aerospace Ltd.
Att. Linda Lacelle
1270 Aberdeen Street
Hawkesbury, Ontario
K6A 1K7

Ship To: Dart Aerospace Ltd.
Att. Linda Lacelle
1270 Aberdeen Street
Hawkesbury, Ontario
K6A 1K7

P.O. Number 2007925

Shipped by our truck

Description	Quantity			Unit
	ordered	shipped	B/O	
DSK-050 Blade Fitting RH - turning only		7		Each
DSK-050 Blade Fitting LH - turning only		7		Each
rec'd 15 CLOS/05/13				
Received by _____				
Thank you for your order.				

P.O. Box 781
Tel. 613) 678-3957 & 678-2782

20 Terry Fox Drive
Fax (613) 678-3956

Vankleek Hill, Ontario, K0B 1R0
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